



Dart Aerospace Ltd.
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D3913-041
Job Sheet 185884



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/6/18

Job Tracking No:

Due Date: 12/7/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/7/18	0.00	0.00	Start Up Large Fab-5		CC
100	Large Fab	1 pcs		12/7/18	0.00	10.00	Large Fab 1		CC
110	QC	1 pcs		12/7/18	0.00	0.00	QC9		MS
120	QC	1 pcs		12/7/18	0.00	0.00	QC5		MS
125	HandFinish	1 pcs		12/7/18	0.00	0.29	HandFinish2		BEB 18-12-3
130	Powdercoat	1 pcs		12/7/18	0.00	0.93	Powdercoat2		BR 18-12-4
135	Packaging	1 pcs		12/7/18	0.00	0.00	Packaging1		HL 18-12-02
140	QC	1 pcs		12/7/18	0.00	0.00	QC3		HL 18-12-05
150	HandFinish	1 pcs		12/7/18	0.00	0.50	HandFinish4		HL 18-12-05
160	QC	1 pcs		12/7/18	0.00	0.00	QC5		HL 18-12-5
170	Packaging	1 pcs		12/7/18	0.00	0.00	Packaging3-2		21 DEC 05 2018
180	QC21-SA	1 Ea		12/7/18	0.00	0.00	QC21		21 9-89 DEC 05 2018

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

M 138834 START: 8:30 OUT: 325° FINISH: 8:45.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	S 112 888
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	123 779
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	S 115 269
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	S 112 730
D3913-7	Rib	2 Ea (2 ea)	90-Start up Operation	S 115 925
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	S 116 572
D3916-041	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	S 128 498
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	S 128 079
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	S 112 356
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	S 125 006
D4017-9	Rib	2 Ea (2 ea)	90-Start up Operation	S 115 755

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

D4020-11	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation
D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish
D2931	Bumper	2 Ea (2 ea)	150-HandFinish
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish
D4021-5	Blanking Plate	2 Ea (2 ea)	150-HandFinish

1x-S109707/S118078

S115213

S125274

S125500

S123441

S102780

S106952

F86435

S076007

S094592

S109991

S108637

S118039

Job Allocations

006869

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	42	0
	D3913-1	1	9	0
	D3913-15	1	16	0
	D3913-3	1	10	0
	D3913-7	2	16	0
	D3913-9	1	8	0
	D3916-041	2	8	0
	D3916-5	3	11	0
	D4016-1	3	214	0
	D4017-7	3	40	0
	D4017-9	2	16	0
	D4020-11	2	21	0
	D4021-1	3	25	0
	D4034-041	1	3	0
	D4034-043	1	3	0
	D4672-1	2	14	0
	M304EX0.75-16F	33	1,189	0
150-HandFinish	AN3-10A	6	201	0
	D2931	2	920	0
	D4021-5	2	29	0
	MS20600-AD4W3	2	311	0
	MS21042L3	6	2,097	0
	NAS1149F0332P	12	1,879	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartero.com www.dartaerospace.com Container No: S132452 Part: D3913 - 041 Job No: 185884 Serial No/Batch: S132452 Revision: Inspector: Exp Date: Instructions: Various STC's Date: 11/28/18		FAULT CATEGORY <table style="width:100%; border: none;"> <tr> <td style="width:15%;">☐ Pressure/Forced</td> <td style="width:15%;">☐ Temperature/Cure</td> <td style="width:15%;">☐ Power Loss/Surge</td> <td style="width:15%;">☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Set-up</td> <td>☐ Folio/Program</td> <td>☐ Outside Dimensions</td> </tr> <tr> <td>☐ Centre Not Concentric</td> <td>☐ BOM/Route</td> <td>☐ Grain</td> <td>☐ Over/Under tolerance</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Part Incorrect</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave</td> <td>☐ Inspection Incomplete/Unqualified</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Cuffs</td> <td>☐ Contamination</td> <td>☐ Out of Sequence</td> <td>☐ Part Moved</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ Countersink</td> <td>☐ Off-set</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Heat Treat</td> <td>☐ Cut Too Short</td> <td>☐ Mislabeled</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Wave/Twist in Tube</td> <td>☐ Instructions Incomplete/Unclear</td> <td>☐ Fit/Function</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Misaligned/off center</td> <td>☐ Turning Sequence</td> </tr> </table>						☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence
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